

Work Order ID 140263

December 18, 2015 9:56:06 AM

140263

Phase cut week of
Jan 4 - 8 / 2016.

Page 1

Item ID: D3805-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plate

Stop *NS2*

Start Date: 12/18/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

SA

Date: 12/18/2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3805

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.03

1-Cut as per Dwg D3805

Dwg Rev: C

Prog Rev: C

2-Debur if necessary

(10)

Dec 16 / 01 / 07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(10)

Dec 16 / 01 / 07

December 18, 2015 9:56:06 AM

Item ID: D3805-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plate

Stop *NS2*

Start Date: 12/18/2015 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 1/8/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

130 0.00
130
 Brake NC
 Memo 0.01
 Brake NC
 Form as per Dwg D3805 using Jigs DT8261 and DT8326

140	QC5- Inspect part completeness to step on W/O	0.00	DAS 38 9-89 JAN 08 2016
140			
QC	Memo	0.00	
Quality Control			

Work Order ID 140263

December 18, 2015 9:56:06 AM

140263

Page 3

Item ID: D3805-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plate
Start Date: 12/18/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/8/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>WA001</i>	0.00				<i>10</i>		<i>16-01-08</i>	<i>MSL</i>
150									
Packaging	Memo	0.00							
Packaging	LOCATION WA001								
160	QC21- Final Inspection - Work Order Release	0.00							
160						<i>MS</i>		<i>JAN 07 2016</i>	
QC	Memo	0.02							
Quality Control									

MS JAN 07 2016

Picklist Print

December 18, 2015 9:56:16 AM

Page 1

Work Order ID: 140263

140263

Parent Item: D3805-1

D3805-1

Parent Item Name: Plate

Start Date: 12/18/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC
IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	409.7700	1.862	19.6			

M304S18GA

304/316 .050 Sheet

on 16/01/07

Location

Loc Qty

Loc Code

MAT020

402.07

M128435

22.37

M132797

5

M133328

214.7

M133587

160

MAT20

7.7

M131700

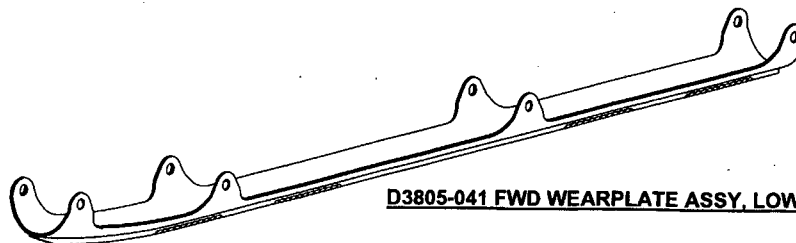
7.7

15.2

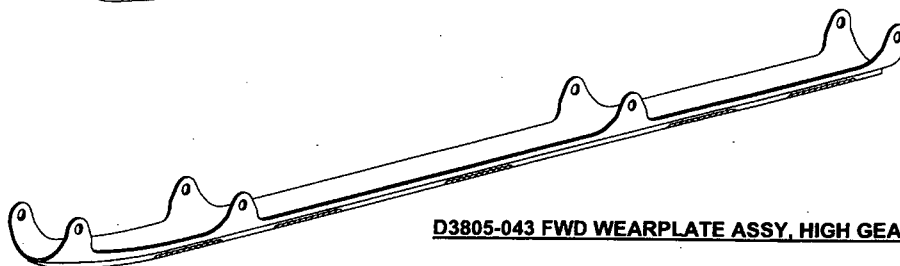
2.3

8 7 6 5 4

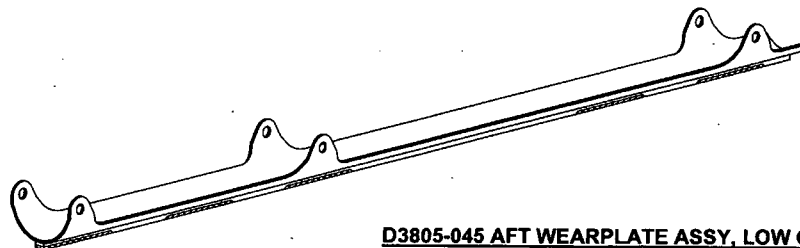
3 2 1



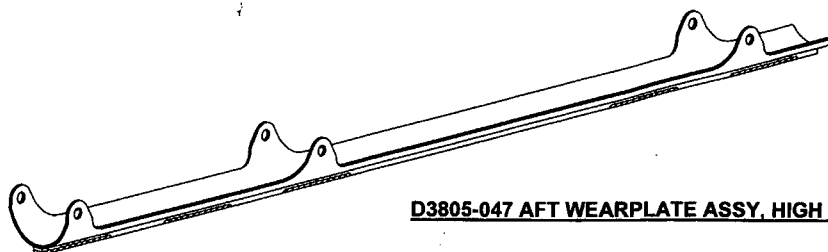
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

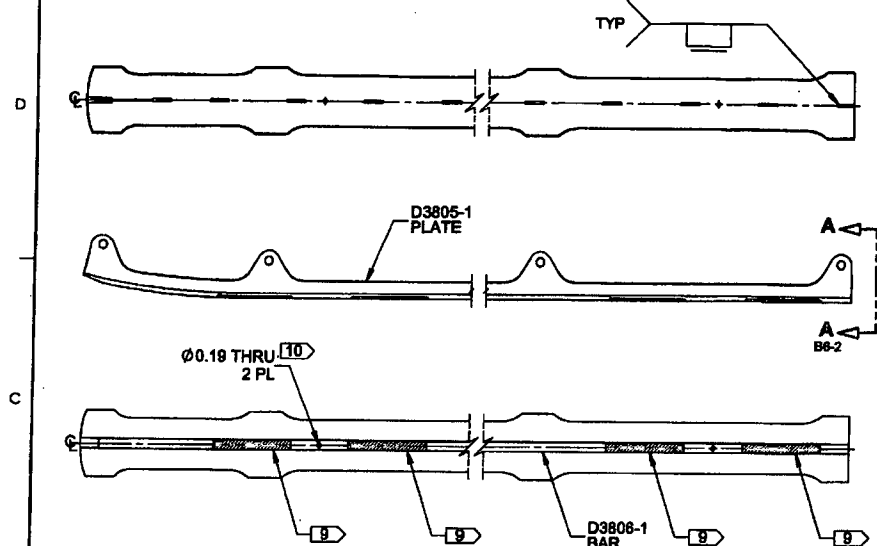
RELEASED
2014-04-13

20151218

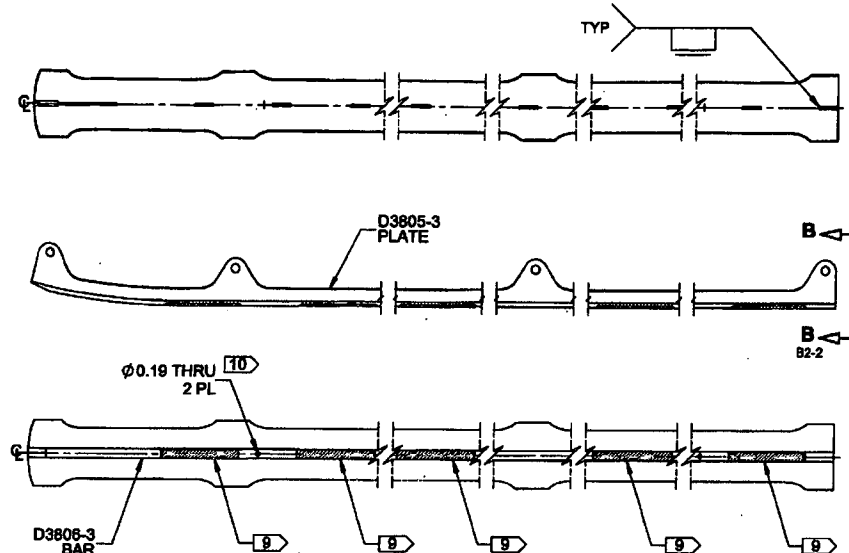
SH 140263

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1), REVISE NOTE 11, SHEETS 2&3 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

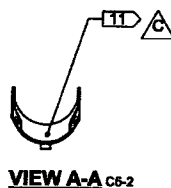
8 7 6 5 4 3 2 1



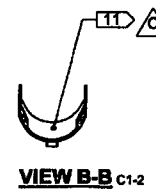
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C6-2



VIEW B-B C1-2

RELEASED
2014-04-13

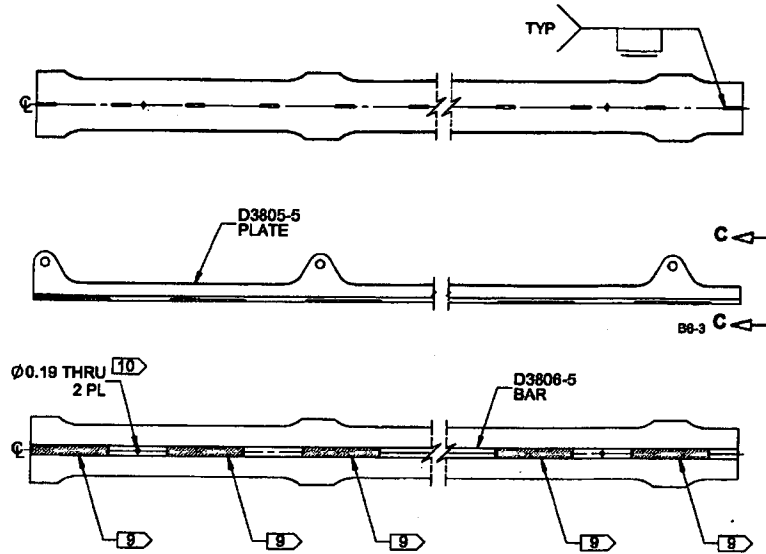
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2058B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 006 4.9.

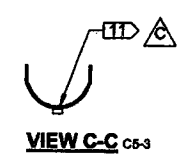
DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3805	SHEET 2 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

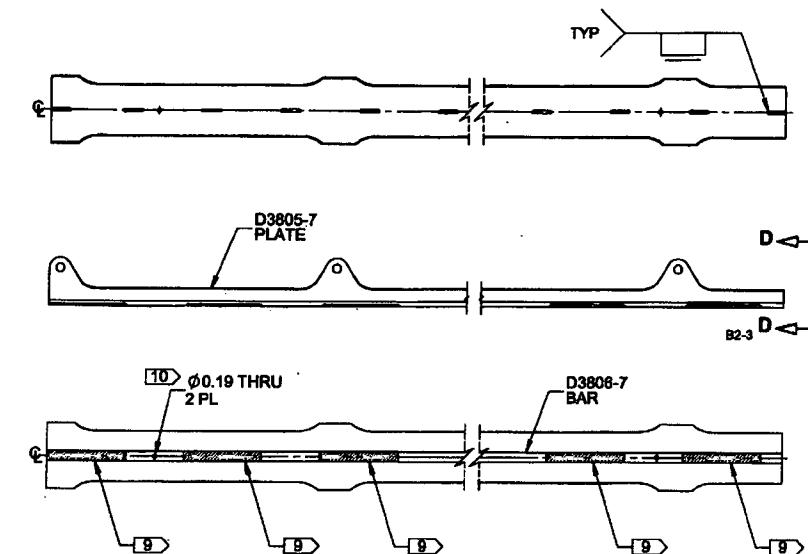
8 7 6 5 4 3 2 1



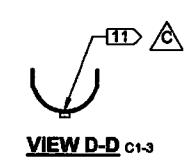
D3805-045 AFT WEARPLATE ASSY.



VIEW C-C C5-3



D3805-047 AFT WEARPLATE ASSY.



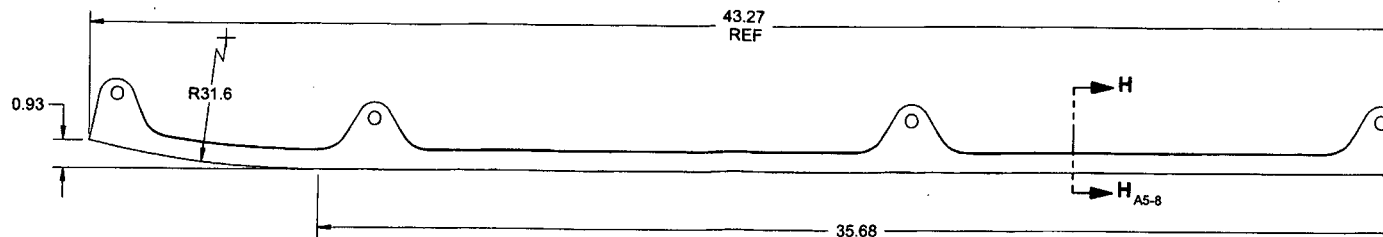
VIEW D-D C1-3

RELEASED
2014-04-17

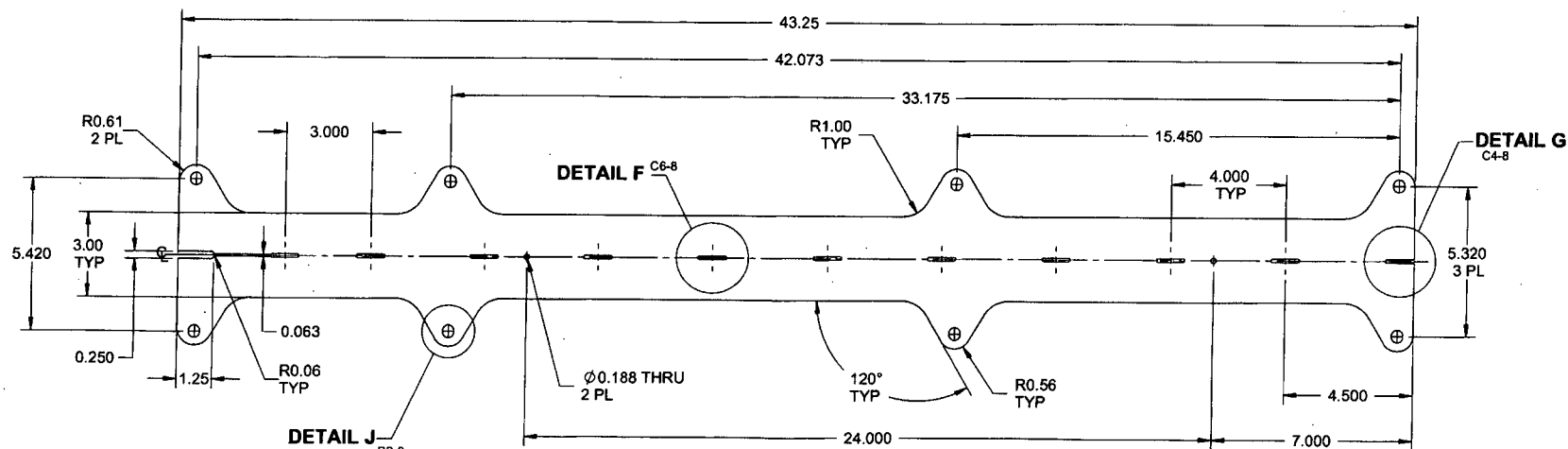
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3805	SHEET 3 OF 8
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPIRATION DATE OF THE DOCUMENT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

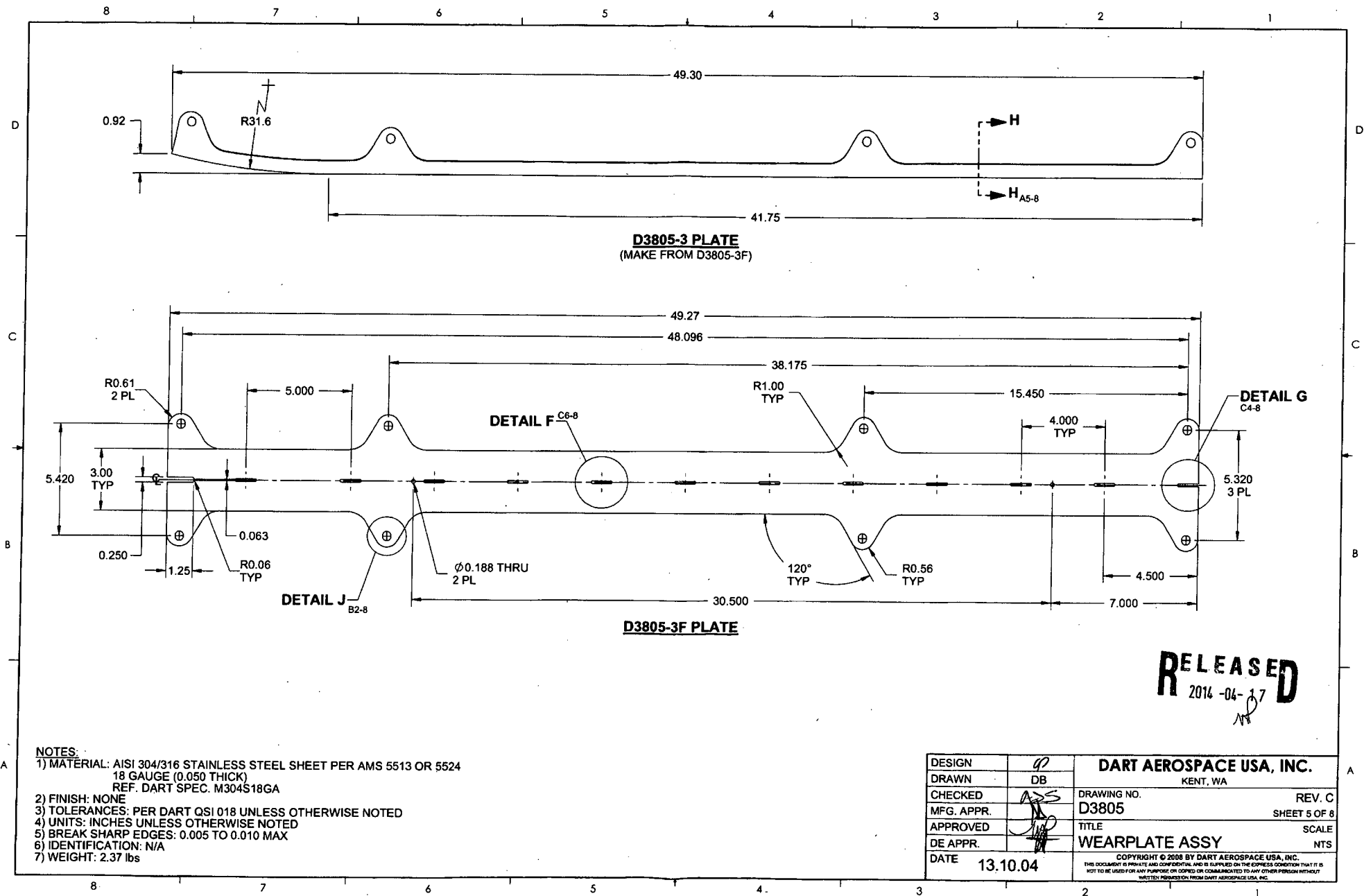
RELEASED
2014-04-17

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.37 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ADS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

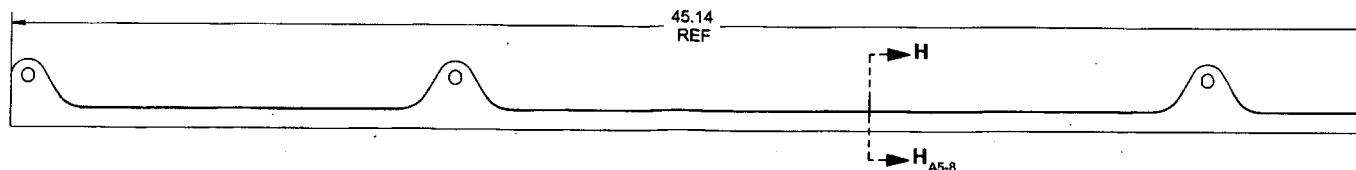


RELEASED
2014-04-17

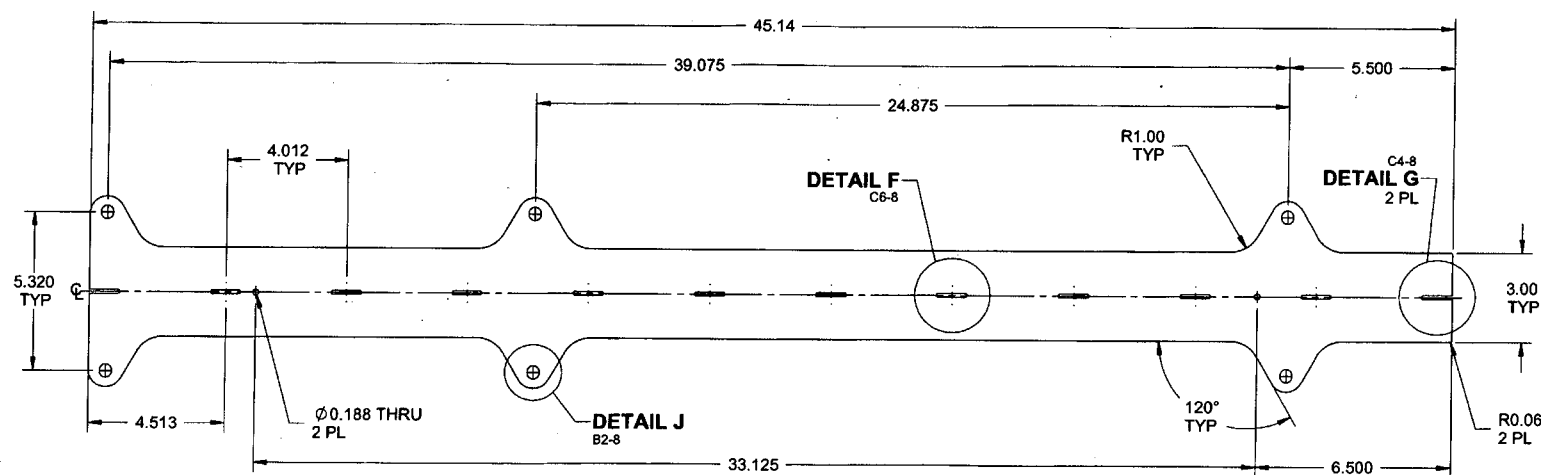
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.06 lbs

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV.
MFG. APPR.	AS	D3805	SHEET 6 OF
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NT
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3805-7 PLATE
(MAKE FROM D3805-7F)

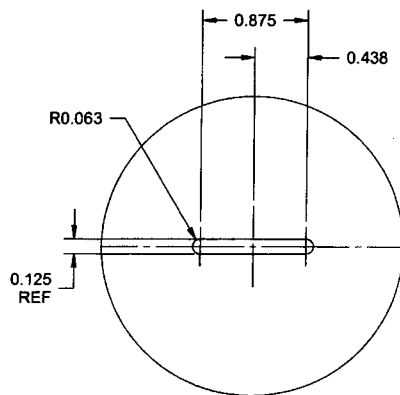


D3805-7F PLATE

RELEASED
2014-04-17

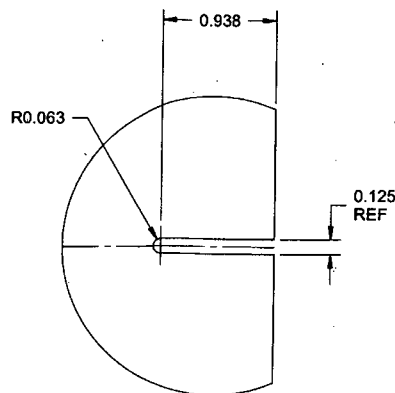
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



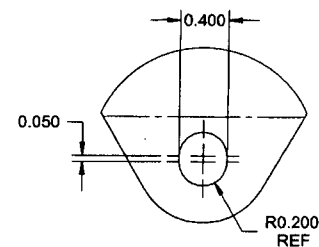
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



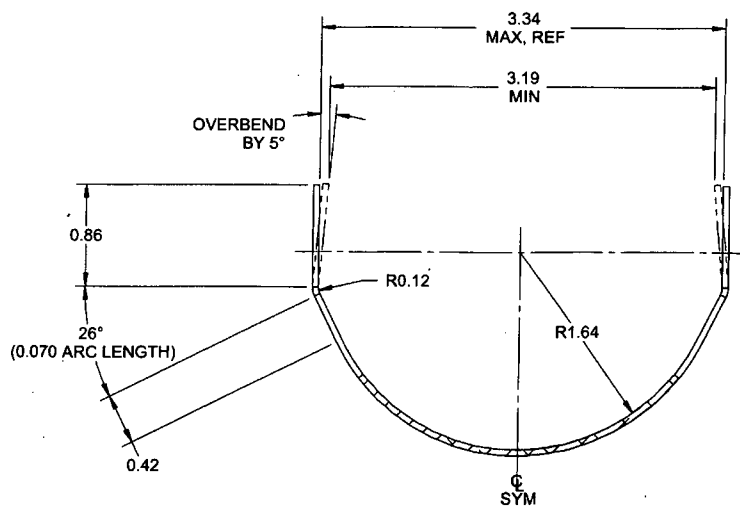
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
2014-04-10

DESIGN	GP	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

